

Date: Thursday, 8/30/2007 3:49:31 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 34349	
Estimate Number : 10519	
P.O. Number : <i>N/A</i>	Part Number : D2855
This Issue : 8/30/2007	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : A
Previous Run : 30279	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/30/2007
Checked & Approved By : <i>[Signature]</i>	Qty: 30 Um: Each
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING  
Issue P/O: *4507*  
Cast per Dwg D2855  
Material Release Note Required

*Cd 07/08/31*

*(30)*

2.0	D2855P	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)  
CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
Recieve & Inspect for Transit Damage  
Ensure Material Release Note is attached

*[Signature]* *07/09/10* *(30)*

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

*counter*  
*07/09/10* *(30)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
1- Drill as per Dwg D2855 using DT8235  
2- Open holes to 19/64"  
3- Deburr

*FF 07-10-18 30*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 8/30/2007 3:49:31 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 34349

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/27/10/18 (30) counter

7.0

POWDER COATING

POWDER COATING



M105068



(30x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.f. 07/10/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT

07-10-22

(30x)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 60.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225

Insert

M100621

or AKS7-1032-225

or ALS4-1032-225

or AKS4-1032-225

F2 (30)

10.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

F2 07/10/22 (30)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5/27/10/22 (30) counter

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-14

F2 07/10/22 (30)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: AD Date: 07/10/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/30/2007 3:49:31 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 34349

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



34

Comment: FINAL INSPECTION/W/O RELEASE

AD 07/10/23

Job Completion



U 8.10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

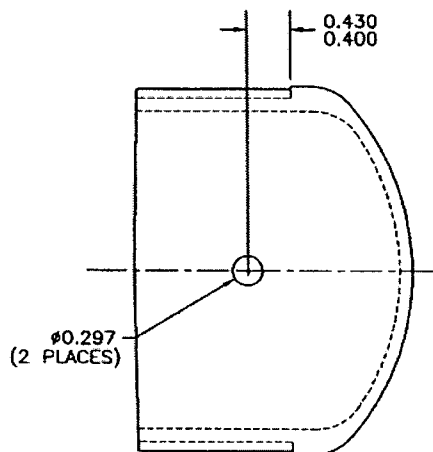
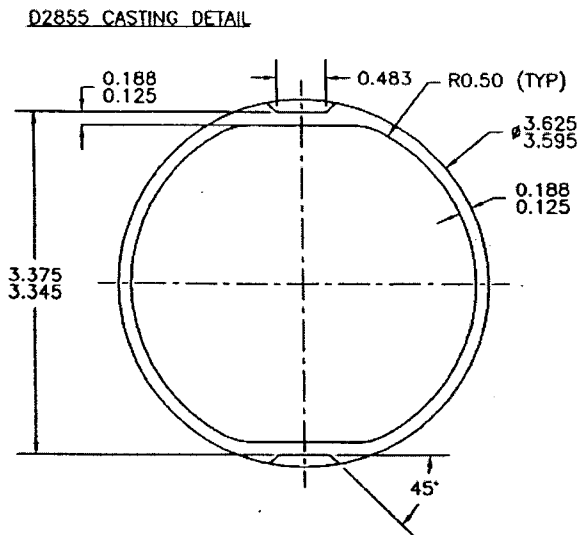
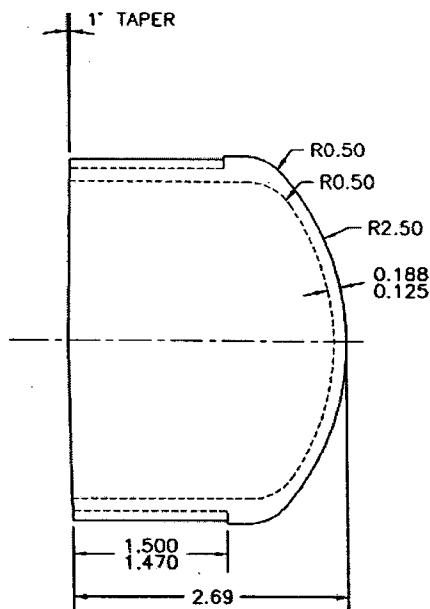
**NOTE:** Date & initial all entries

**DART**

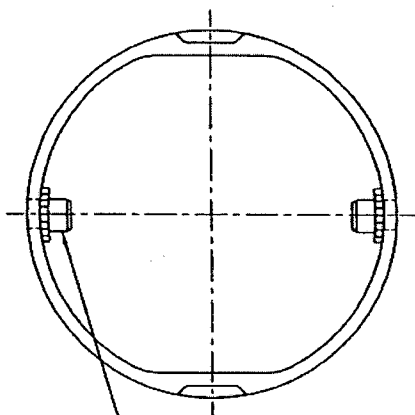


DESIGN#	44	DRAWN BY	44	DART AEROSPACE LTD
CHECKED	CP	APPROVED	44	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.12	DRAWING NO.	D2855	REV. A
		TITLE	CAP	SHEET 1 OF 1
				SCALE
				NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)		

RELEASED  
98.12.14 DS



D2855 FINISHING DETAIL



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

43 KF 99.09.12

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34349

# Aluminum Foundry Ltd

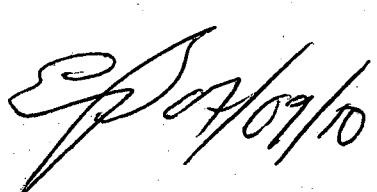
714-716 Calais  
Dorval, Québec H9P 2P3  
Tel: (514) 631-1331  
Fax: (514) 631-8448

email: info@foundryafpw.com

## Packing Slip

Packing Slip No.: 32147  
Shipped Date: Sep 07, 2007

<b>Sold to:</b>	<b>Ship to:</b>
<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7  Tel. (613) 632-3336 Fax (613) 632-4443	<b>DART AEROSPACE</b> 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
<b>Order No.:</b> 4509	
<b>Shipper By:</b> PUROLATOR	
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A    <b>Received by:</b>  <b>Date:</b>	30
<b>Comment:</b>			



CERTIFICAT DE CONFORMITÉ  
 CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
 ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714-716 CALAIS, DORVAL, QC H9P-2P3  
 TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à  
 Shipped

**DART AEROSPACE**

A.F. & P.W. Série no./Serial no.

**1270 Aberdeen Street**

Date: **07/09/2007** Packing Slip No. **32147**

**Hawksbury, ON, K6A 1K7**

Votre No. Commande **4509**  
 Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications	Note d'information Incoming release note
30	D 2855 CAP	Z098046	A356.2	Ingot 348
Analyse Analysis (as in Ingot)				
(Si)	7.00%	(Al)	balance	
(Fe)	0.08%			
(Cu)	<0.01%			
(Mn)	<0.01%			
(Mg)	0.44%			
(Zn)	<0.01%			
(Ti)	0.16%			
Donne Yield :	Résistance à la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de  
 For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
 ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :  
 Par/Per :

Coc-100

# DART

## Purchase Order

Date Aug 31, 2007	Page 1
Purchase Order Number PO00004509	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

REVISED

FAKED  
06/09/07

### Vendor Address:

Aluminum Foundry & Pattern Works (1988)  
714-716 Calais  
Dorval, QC H9P 2P3  
Phone (514) 631-1331  
Fax (514) 631-8448

### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-ALU001	Aug 31, 2007	N30	Purolator	Sep 21, 2007

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
30.0000	D2855P	Cap Comments: AS PER DWG D2855 REV. A MATERIAL: CAST ALUMINUM ALLOY A356.2	9/21/2007	No	<del>REDACTED</del>	Each	<del>REDACTED</del>
<div>9/27/09/10</div> <div>07/01/13</div> <div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
Comments:		Tax Summary: GST GSTME GSTND		Less: included tax			
Entered By: CLAVOIE				Subtotal			
Approved By:				Total tax			
				Total purchase order in			
				CAD Dollars			



# DART

## Purchase Order

Date Aug 31, 2007	Page 1
Purchase Order Number PO00004509	

### FXED

07/08/03

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

#### Vendor Address:

Aluminum Foundry & Pattern Works (1988)  
714-716 Calais  
Dorval, QC H9P 2P3  
Phone (514) 631-1331  
Fax (514) 631-8448

#### Ship To:

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-ALU001	PO Date Aug 31, 2007	Terms N30	Ship Via Purolator	Expected Arrival Sep 21, 2007
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
30.0000	D2855P	Cap Comments: AS PER DWG D2855 REV. A MATERIAL: CAST ALUMINUM ALLOY A356.2	9/21/2007	No	<del>114.00</del>	Each	<del>114.00</del>
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div>							
<div><div>Comments:</div><div><div>Tax Summary: GST GSTME GSTND</div><div>Entered By: CLAVOIE</div><div>Approved By:</div></div><div><div>Less: included tax Subtotal Total tax Total purchase order in CAD Dollars</div></div></div>							

11/11/11

1

11/11/11

1